

Work Order ID 166311

Thursday, September 14, 2017 2:46:09 PM

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Item ID: D3720-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Spacer

Start Date: 9/15/2017 Start Qty: 20.00

20

Cust Item ID:

Required Date: 9/20/2017 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: W Date: SEP 14 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3720

Rev A

100

0.06

100

FLOW WATER JET

Waterjet

Memo

0.83

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

2517/09/16DAS
40
9-89

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.20

Quality Control

2517/09/16DAS
40
9-89

Quality Control

20 SEP 18 2017

20X _____ 17/09/18

20 SEP 19 2017

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Item ID: D3720-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Spacer
Start Date: 9/15/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 9/20/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	2.00							
Quality Control									

17/9/21

SEP 20 2017

Picklist Print

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Work Order ID: 166311

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Parent Item: D3720-1

D3720-1

Parent Item Name: Step Spacer

Start Date: 9/15/2017

Required Date: 9/20/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased		No		100	sf	56.3000	0.085	1.789474			
M6061T6S 125									**			17/09/16	DAS 40 9-89
6061-T6 .125 Sheet													

Location

Loc Qty

Loc Code

MAT019

56.3

m136896

1.3

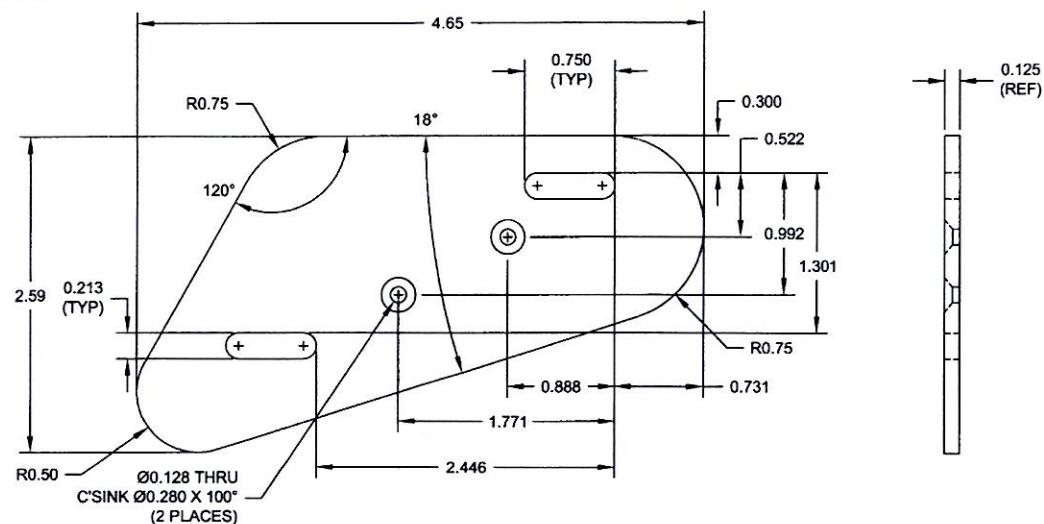
m137980

23

m138346

32

2

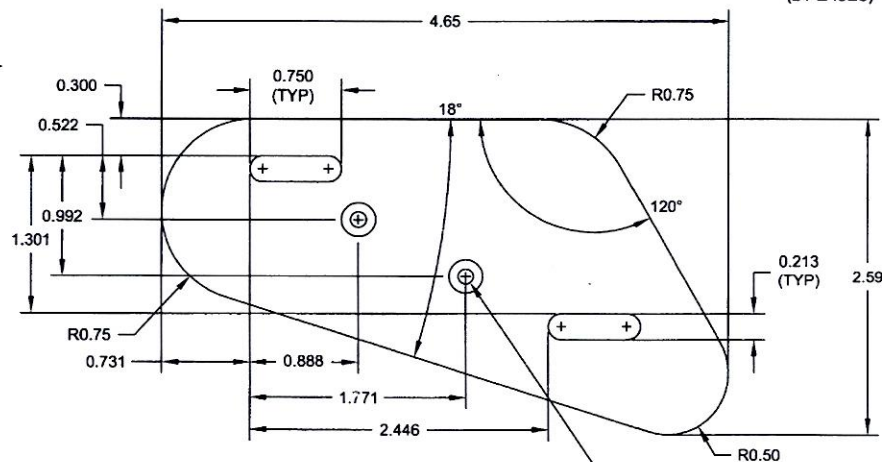


D3720-1 STEP SPACER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166311

SEP 14 2017

RELEASED



D3720-2 STEP SPACER

NOTES:

- 1) MATERIAL: 6061-T6 (OR -T62) ALUMINUM SHEET 0.125 THICK (PER QQ-A-250/11 OR AMS 4025/4027) (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

A		NEW ISSUE		PH	07.12.27
REV.		DESCRIPTION		BY	DATE
DESIGN	<i>AK</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	<i>AK</i>				
CHECKED	<i>AK</i>	DRAWING NO.		REV. A	
MFG. APPR.	<i>AK</i>	D3720		SHEET 1 OF 1	
APPROVED	<i>AK</i>	TITLE		SCALE	
DE APPR.	<i>AK</i>	STEP SPACER		1:1	
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